

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014360**Date Inspected:** 12-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG Assembly Yard

8BE+8CE

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 005 located at OBE8C bike path side of segment. Welder is identified as Mr. Han Xiaofeng (054467). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-3G (3F)-Repair-1 and CWR1525 procedure.

Y Location of repairs areas by above noted welder (054467) is located at 400mm.

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 004 located at OBE8C bike path side of segment. Welder is identified as Mr. Han Xiaofeng (054467). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-3G (3F)-Repair-1 and CWR1525 procedure.

Y Location of repairs areas by above noted welder (054467) is located at 620mm.

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Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 004 located at OBE8C bottom plate splice. Welder is identified as Mr. Dai Lu (048659). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-1G (1F)-Repair-1 and CWR1525 procedure.

Y Location of repairs areas by above noted welder (048659) is located at 535, 2710, 3500 and 3930mm.

8AW

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 004 located at CA047 counter weight side of segment. Welder is identified as Mr. Zhao Guanglin (044779). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-2G (2F)-Repair-1 and CWR1222 R2 procedure.

Shield Metal Arc Welding (SMAW) repair welding (build up) was performed on LD ends. Welder is identified as Mr. Xu Zichuan (205098). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-1G (1F)-Repair-1 and WR12503 procedure.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 008 located at SEG043C cross beam side of segment. Welder is identified as Mr. Zang Wei (066413). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2114-FCM-1.

7AW

Flux Core Arc Welding (FCAW) welding was performed on weld joint 003 located at OBW7N counter weight side of segment. Welder is identified as Mr. Liu Xiaolin (067079). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2231T-1.

Miscellaneous Work In Progress

QA Inspector observed ZPMC's personnel performing various job functions at Tail Assembly Yard. Locations and description of work are as followed:

7DW

1. Heat straightening was performed on the deck plate 649A to cross beam plate located between panel points 56 & 58 per HSR1 (B)-8434.

9AE+9BE

1. Segments were moved to trail assembly yard for the required work.

NDT Observation

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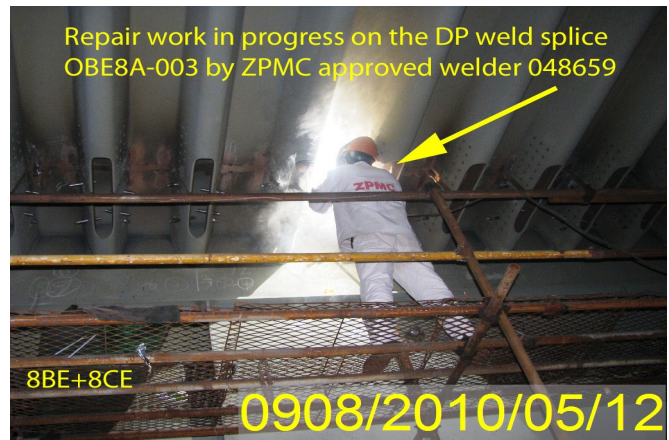
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This QA Inspector observed ZPMC Magnetic Particle Testing (MT) Technician performed MT on various locations in the trial assembly yard. Locations and indications are as followed:

7CW+7DW

1. Deck plate weld splice OBW7A-002, 003 and 004 temporary attachment areas.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (150-0042-2372), who represents the Office of Structural Materials for your project.

Inspected By:	Alaniz,Joe	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
